

IN THE CLAIMS:

1. (currently amended) A process of producing an inner profile in a tube or hollow profile comprising:

providing one of a tube or hollow profile having an internal through opening and a constant cross section over the length thereof,

inserting the tube or hollow profile into a supporting sleeve, with a first tube end being axially supported;

placing a pressure-loaded annular die on to a second tube end;

pressing a forming die with an outer profile into the tube or hollow profile from the second tube end for producing the inner profile; and

allowing a return of the annular die under a pressure load in the opposite direction of that of pressing in the forming die.

2.-5. (cancelled)

6. (previously presented) A process according to claim 1, wherein a pressure load on the annular die is reduced with an increasing return path.

7. (currently amended) A process according to claim 6 A process of producing an inner profile in a tube or hollow profile comprising:

inserting the tube or hollow profile into a supporting sleeve, with a first tube end being axially supported;

placing a pressure-loaded annular die on to a second tube end;

pressing a forming die with an outer profile into the tube or hollow profile from the second tube end for producing the inner profile; and

allowing a return of the annular die under a pressure load in the opposite direction of that of pressing in the forming die,

wherein the pressure load on the annular die is reduced in such a way that the sum of an integrated wall friction between the tube or hollow profile and the

supporting sleeve in the region of deformation, and the pressure load on the annular die remains approximately constant.

8. (previously presented) A process according to any one of claim 1, wherein the inner profile is a splined shaft profile.

9. (previously presented) A process according to any one of claim 6, wherein the inner profile is a splined shaft profile.

10. (previously presented) A process according to claim 1, wherein the inner profile is a ball track profile.

11. (previously presented) A process according to claim 6, wherein the inner profile is a ball track profile.

12. (previously presented) A process according to claim 1, wherein the second tube end is only radially supported by the sleeve.

13. (previously presented) A process according to claim 1, wherein the supporting sleeve is axially longer than the tube or hollow profile.

14. (previously presented) A process according to claim 1, wherein the annular die retracts during the step of pressing in response to a backward flow of material.

15. (previously presented) A process according to claim 1, wherein the annular die and pressing die are coaxially arranged.